

Date: Monday, 2/11/2008 2:14:58 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 37367		
Estimate Number	: 10833		
P.O. Number	:	Part Number	: D29331
This Issue	: 2/11/2008 S.O. No. :	Drawing Number	: D2933 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 34629	Material	:
Written By	:	Due Date	: 3/5/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JD 08 02 11</u>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: B34201

*S.F 08/03/08*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

*S.F 08/03/08*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

*S.F 08/03/08*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*S.F 08/03/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 08/03/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 37367

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/03/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JP

08-03-10

(24)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

FL 08/03/11

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/03/11

(4X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423A

8/3/11 50

(42)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 08/03/12

Job Completion



mi 2008/3/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 37367	
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b> D2933-1	
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.135	.135	.135	.135	
B	0.100	0.140		.135	.135	.135	.130	
C	0.100	0.140		.135	.135	.135	.135	
D	0.210	0.230		.226	.222	.222	.220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.507	.508	.508	.508	
I	1.572	1.582		1.579	1.579	1.579	1.579	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.258	.258	
L	0.312	0.317		.313	.312	.313	.313	
M	0.235	0.240		.237	.237	.237	.237	
N	0.100	0.140		.126	.126	.126	.126	
O	0.540	0.560		.542	.542	.542	.542	
P	0.490	0.510		.507	.507	.507	.507	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.497	2.500	2.500	2.500	
S	0.240	0.270		.256	.256	.256	.256	
T	0.100	0.180		.133	.133	.133	.133	
U	1.625	1.635		1.635	1.626	1.626	1.626	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.321	.321	.321	.321	
X	1.125	1.145		1.134	1.135	1.135	1.135	
Y	1.565	1.585		1.574	1.574	1.574	1.574	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> RF	<b>Date:</b> 08/03/08
<b>Audited by:</b> J.L. 08/03/08	<b>Date:</b>
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



**NOTES:**

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- Technical drawing of a mechanical part, likely a bracket or arm, showing dimensions and features. The part is shown in a cross-sectional view. Key features include a vertical flange on the left, a horizontal base, and a curved arm. Dimensions are given in inches with tolerances. Callouts include 'R0.188 (AROUND POCKET)', 'R0.50 (TYP)', 'R1.575', '0.140', '0.100', '1.000', '0.500', '0.115', '0.240', '0.235', 'R0.025', '1.605', and '48.0°'. Surface finish symbols (triangles with letters C and B) are present. A dashed line indicates a centerline. The drawing is labeled 'DHS' and 'EP'.

SECTION B-B






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07.02.12

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C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> BELLEVILLE, ILL.
		
CHECKED	APPROVED	DRAWING NO. REV.
		D2933
DATE	TITLE	SHEET 1 OF
06.11.09	SADDLE INSIDE	2:

REV. 6  
SHEET 1 OF